



Tungsten Carbide Burs with Long Shank (L3 and L6)

Small tungsten carbide burs with long shanks **L3** (3") are perfect for work on small hard-to-reach components.

Tungsten carbide burs with long shanks **L6** (6") are ideal for cost-effective work in deep, hard-to-reach places.

Safety Note

Not suitable for robotic and stationary usage.

Risk of bending. Only use rigid clamping systems/drives.

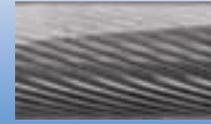


Read the instructions!
= (Please observe the recommended RPM!)

Double Cut



Fine Cut



Safety Information Recommended RPM

When working with long shank burs, the bur must be in contact with the workpiece (or inserted in the bore or slot to be machined) before the machine is turned on. As a rule, the tool must remain in contact with the workpiece for as long as the machine is running. Failure to observe this procedure may result in shank failure and hence, an increased accident risk.

If the continuous contact between the tool and the workpiece is not guaranteed, the **6** idling speeds stated in the table should **not be exceeded**.

For safety reasons, drive speeds **6** with **contact to workpiece** require a reduction in the recommended standard length bur speed from the speeds stated in the table below.

Proceed as follows:

- 1 Determine the workpiece material to be machined.
- 2 Select application.
- 3 Select the cut.
- 4 Select the bur diameter.
- 5 For the recommended reduced speed [RPM] with workpiece contact, please refer to the right-hand side of the table.

1 Workpiece Material/Colour Code		2 Application	3 Cut	
Steel, cast steel	Non-hardened, non-heat treated steels up to 38 HRC (< 1200 N/mm ²)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steels	Coarse machining = high stock removal Fine machining = low stock removal	Double / Single Fine
	Hardened, heat-treated steels exceeding 38 HRC (> 1200 N/mm ²)	Tool steels, tempering steels, alloyed steels, cast steels	Coarse machining = high stock removal Fine machining = low stock removal	Double / Single Fine
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steel	Coarse machining = high stock removal Fine machining = low stock removal	Double / Single Fine
Non-ferrous metals	High-temperature resistant materials	Nickel based alloys, cobalt based alloys (aircraft engine and turbine construction)	Coarse machining = high stock removal Fine machining = low stock removal	Double / Single Fine
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron	Coarse machining = high stock removal	Double / Single
			Fine machining = low stock removal	Fine

Example

Tungsten Carbide Bur, L6, Double Cut, Diameter: 1/2".
Coarse machining of non-hardened and non-heat-treated steels.

Recommended Reduced Speed with Workpiece Contact: 7,000 RPM

4 Dia. [Inches]	6 Maximum Rotational Free Speed [RPM] (No contact to the workpiece)		5 Recommended Reduced Rotational Application Speed [RPM] (With contact to the workpiece)	
	Shank Length [Inches]			
	L3 (3")	L6 (6")	L3 (3")	L6 (6")
1/8	10,000	-	31,000	-
1/4	6,000	-	15,000	-
5/16	-	6,000	-	11,000
1/2	-	3,000	-	7,000